

Date: Thursday, 17/07/2008 11:45:30 AM
 User: Julie Lecocq

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : ARM |
| Job Number : 40580 | |
| Estimate Number : 11969 | |
| P.O. Number : | Part Number : D2065 |
| This Issue : 17/07/2008 S.O. No. : | Drawing Number : D2065 UNDER REVIEW <i>RU</i> |
| Prsht Rev. : NC | Project Number : N/A <i>03.07.17</i> |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B1 |
| Previous Run : 34287 | Material : |
| Written By : | Due Date : 06/08/2008 Qty: 10 Um: Each |
| Checked & Approved By : <i>JUL 08.7.17</i> | |
| Comment : Est: E 02.04.15 Added Dwg Rev.B1NG | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0500V035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|

*W049**RU 03.07.17***Comment:** Qty.: 1.7063 f(s)/Unit Total: 17.0625 f(s)

304 RD Tube .500 x .035W

0.500 x 0.049

Seamless Tube (Ref. QSI 017 4.1.1.2) as per Dwg D2065 using DT8012.

Note: 1 end only

Batch: *M 108 324**PTO**86 08/07/23*

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|

**Comment:** BAND SAW

Punch 1/2" OD x .035" Wall 304/316 SS

Cut to length as per Dwg D2065

Form as per Dwg D2065 and template DT8251

Drill 0.188" Dia holes as per Dwg D2065 and template DT8251

Deburr

*W08-225**use for w/o 40748*

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

| | | |
|-----|----------------|----------------|
| 4.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|

**Comment:** POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 08.07.17 | 1 | USE AISI 304/316 TUBING (0.500" O.D. 0.049" WALL) DRAWING IN PROCESS OF APPROVAL PERMANENT CHANGE | PH | 08.07.17 | ALL | PH 08.07.17 QSI 042 | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 17/07/2008 11:45:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 40580

Part Number: D2065

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A U

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA for w/o 40580

U 08/07/25

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/25

Job Completion



U 08/07/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

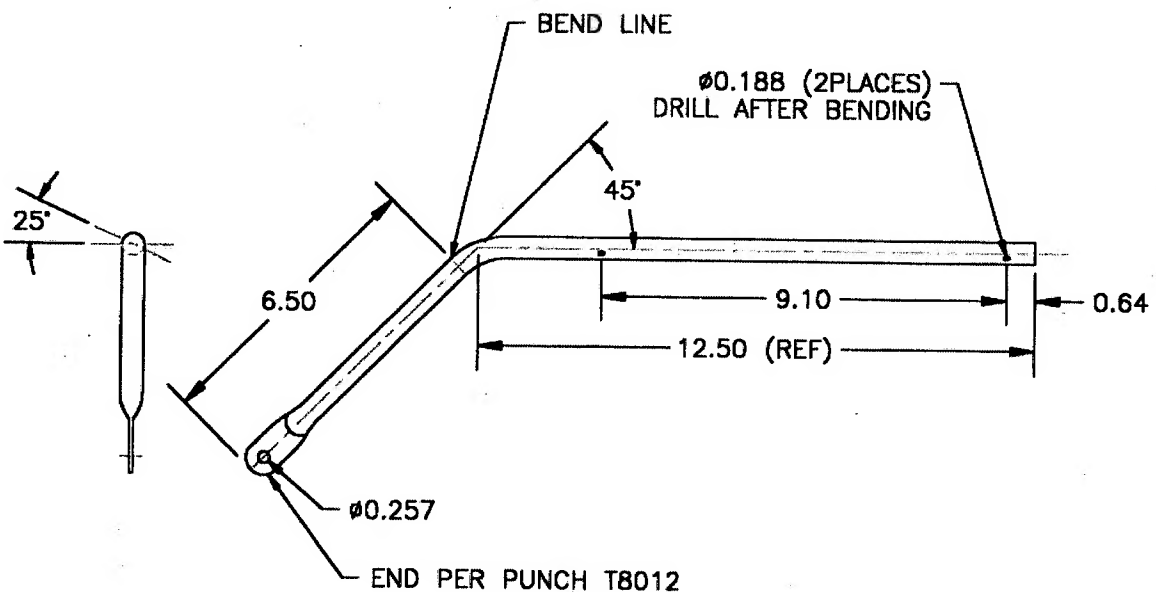


RELEASED
96/11/14 BxJ

| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | REV. B |
|------------|------------|--|--------------|
| B WILLIAMS | B WILLIAMS | | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 1 |
| DATE | | D2065 | |
| 92.03.12 | | ARM | SCALE |
| | | | 1:4 |
| B | 96.02.06 | RE-DESIGN | |
| BI | 92.03.25 | ADD FINISH | |

UNDER REVIEW

03.05.14 ~~PT~~
USE 0.049" WALL
PT 03.07.17



D2065 CUT LENGTH 19.5

0.049 ~~PT~~ 03.07.17

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 055 4.3 ~~BI~~

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40580

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries